

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002899**Date Inspected:** 10-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** C.M. Chen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Deck Sections**Summary of Items Observed:**

The Quality Assurance (QA) Inspector,Mahlon Lindenmuth,arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following:

QA Inspector, Lindenmuth, observed the work being performed in Bay 2 of the New OBG. ZPMC personnel were performing various functions related to the fabrication of the OBG Side Plates and Bottom Plates as well as the deck sections in the jig fixture. The fabrication performed includes but is not limited to the preparation of areas where temporary welds for strongbacks are located, bevel preparation and welding of the Complete Joint Penetration welds (CJP)on Side Plates and Bottom Plates,heat straightening of Side Plates and Bottom Plates.

South Jig Fixture:

*Segmnet 3AE- Caltrans QA Inspector Lindenmuth, observed ZPMC personnel aligning and plumbing the segments FL1-1 North and the F11-1 North to the segment FL2.

*Caltrans QA Inspector, Lindenmuth, also observed ZPMC personnel surveying the segments and setting up scaffolding on the 4BE and the 3AE segments.

Shop Welding:

*Caltrans QA Inspector, Lindenmuth, observed ZPMC personnel backgouging the Complete Joint Penetration (CJP) weld joining SP332-001 and SP359-001. The purpose of the backgouging was to remove discontinuities discovered by ZPMC QC personnel performing Ultrasonic Testing (UT) of the weld joint.

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*Caltrans QA Inspector, Lindenmuth, observed ZPMC personnel preheating the CJP weld joint on SEG023A-003. The root pass of the groove weld had already been completed using the FCAW weld process. The fill passes and cover will be completed using the SAW weld process.

Summary of Conversations:

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Lindenmuth,Mahlon	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
